Dart Aerospace Ltd.

Date: Thursday, 3/13/2008 10:20:06 AM
User: Kim Johnston

SPLIT - 2

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37928 - 2
Estimate Number : 10012
P.O. Number :
This Issue : 3/13/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 37154
Written By :
Checked & Approved By : 08 03 13
Comment : Est Rev:D Removed from 9 digit 05-10-25 JLM

Drawing Name : LUG ASSEMBLY
Part Number : D27363
Drawing Number : D2736 REVA
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 4/10/2008 Qty: ~~40~~ 13 Um: Each

Additional Product

Job Number:

Seq. #	Machine Or Operation:	Description :
1.0	D2591	Lug

Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) B 37857 → 20x
Pick:
Qty Part Number Description Batch B35659 → 4x
1 D2591 ✓ Lug B33508 → 9x SP 08-04-03

Seq. #	Machine Or Operation:	Description :
2.0	D27353	Lug Bracket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) B 35434 → 19x
Pick:
Qty Part Number Description Batch B37439 → 7x
1 D2735-3 ✓ Lug Bracket B37439 → 13x SP 08-04-03

Seq. #	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1 SP 08-04-15 (20)
Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484
Steel Rod Batch: M106138 → M100372. SP 08-04-03.

Seq. #	Machine Or Operation:	Description :
4.0	QC9	VISUAL WELDING INSPECTION

PD 08-04-16 (20)
~~PD 08-04-15 (13)~~
Comment: VISUAL WELDING INSPECTION

Seq. #	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP

08-04-16 (20)
~~08-04-15 (13)~~
Comment: INSPECT WORK TO CURRENT STEP

Form: process

Date: Thursday, 3/13/2008 10:20:06 AM
User: , Kim Johnston

Process Sheet

30 min.
18/04/2018
S.064 10.0
#1 399.9 F
#B 37928 F
#D. 27363 F

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LUG ASSEMBLY

Job Number: 37928 **Part Number:** D27363

Job Number:

Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	M 107552 20
	Comment: HAND FINISHING RESOURCE #1 Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3		BL 08-04-18
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	20K
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		M. L 08/04/18
8.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		sty/A 4/21 20
9.0	QC21	FINAL INSPECTION/W/O RELEASE	08/04/22
	Comment: FINAL INSPECTION/W/O RELEASE		

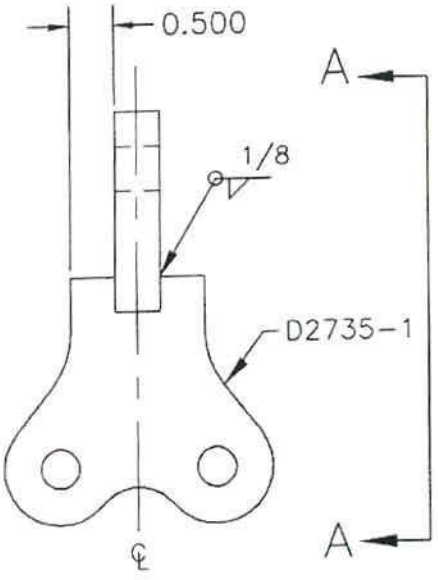
Job Completion

U 08.04.22

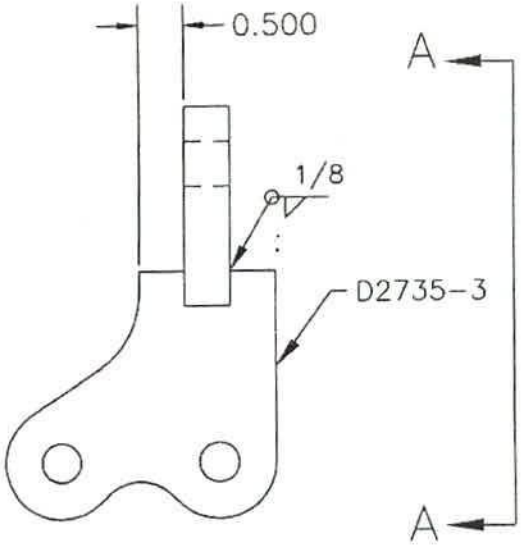
DART

QA COPY ISSUED

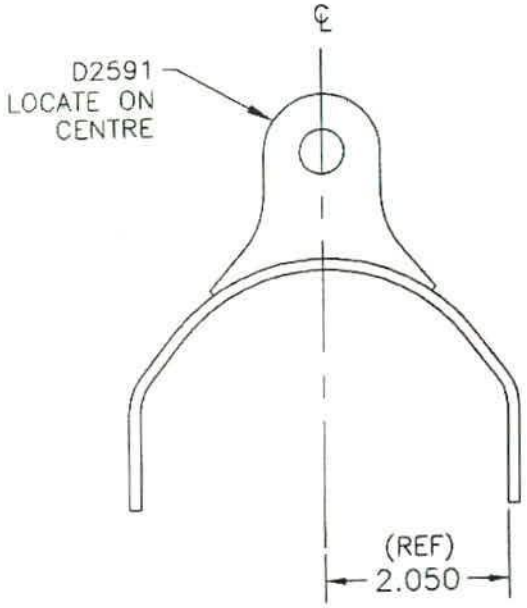
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (℄)

37928

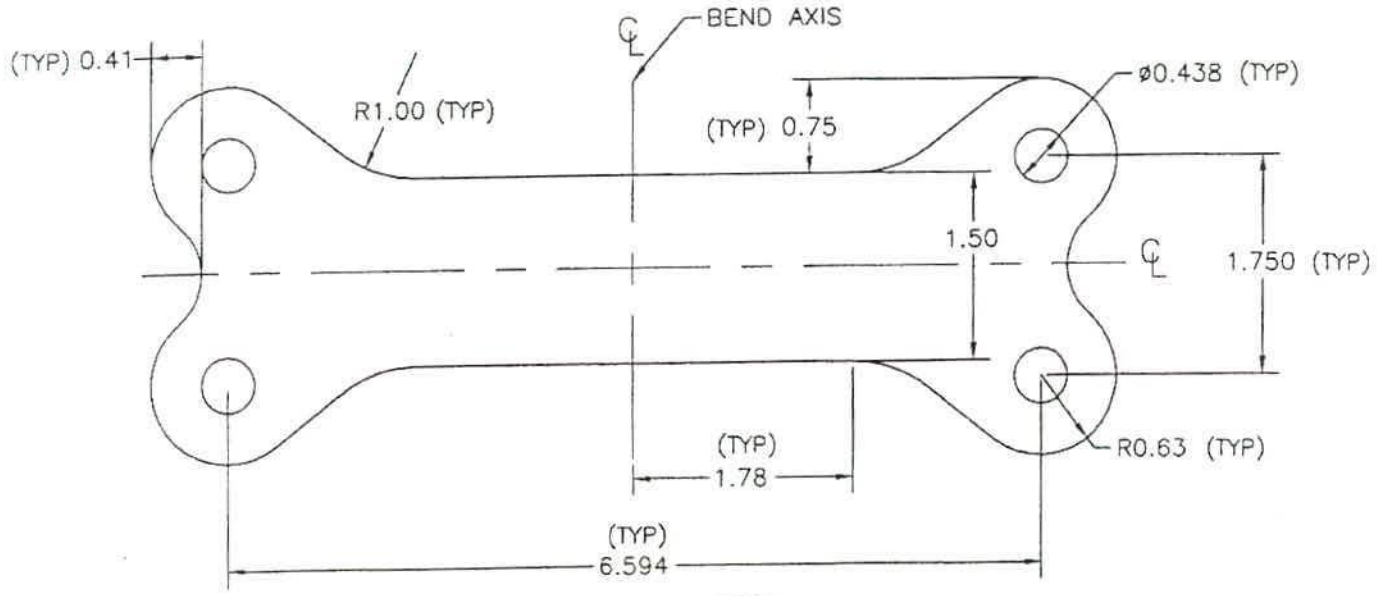
RELEASED
97/12/24 DS
ECN 057

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

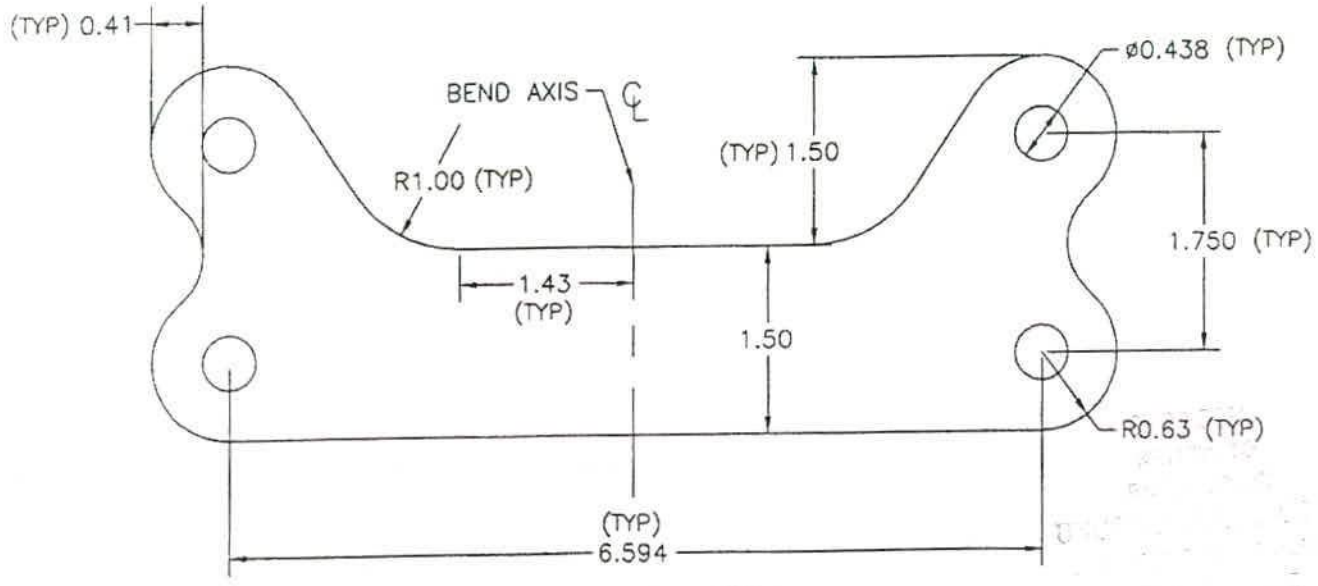
A	97.12.14	NEW ISSUE
B	98.10.23	UPDATE MATERIAL (TSR A1114)
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)

DA COPY ISSUED

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (℄)

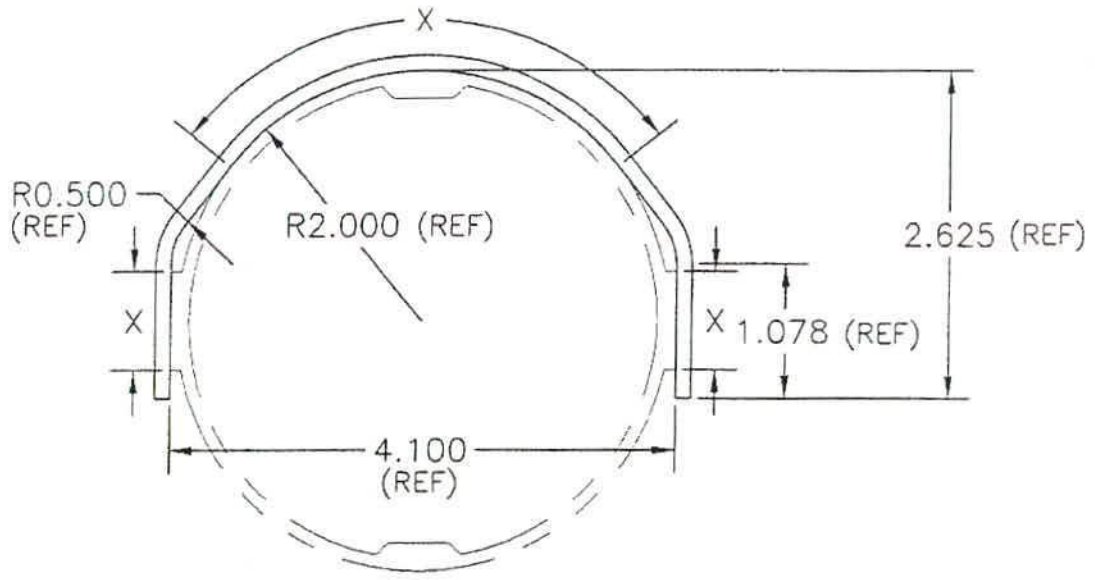


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (℄)

37928

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

37128